



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEL135M-2901-101-07
Job Sheet 188490



Part No: RBEL135M-2901-101-07

Job Qty: 2 pcs

Part Name: Geared Pulley



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEL135M-2901-101 Rev.A IPP Rev. A 18.11.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	2 pcs	1/18/19	1/18/19	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	JAN 24 2019
110	Packaging 2-1 - Receive - B4B	2 pcs	1/18/19	1/18/19	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B	JAN 24 2019
120	QC 6	2 pcs	1/18/19	1/18/19	0.00	0.00	QC 6 - 38 QC 6 - 42 QC 6 - 9 QC 6 - 68	JAN 24 2019
130	Packaging 3-1 - Stock - B4B	2 pcs	1/18/19	1/18/19	0.00	0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B	JAN 24 2019
140	QC 21 - SA	2 pcs	1/18/19	1/18/19	0.00	0.00	QC 21 - SA - 21	JAN 25 2019

Part Op 100 - Issue P/O to PJ MACHINAGE; P/O 042245 - Manufacture RBEL135M-2901-101-07 as per DWG.
Descriptions: -Certificate of Conformity is required
110 - Certificate of Conformity is required

x4 In hrs Jan 10 - 2019.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEL135M-2901-101-07P	Geared Pulley	2 (1 ea)	100-Purchasing	5147708

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBEL135M-2901-101-07P	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA C

Work Order update only ☐

Wo

Container No: S147717



Part: RBEL135M-2901-101-07

Job No: 188490

Serial No/Batch: S147717

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/24/19

Dat

AGAINST DEPARTMENT/PROCESS

Work	Skid-tube	Cross tube	Water Jet	Engineering
ap	Machining	Small Fab	Prod. Eng. Coord.	Quality
-is	Thermoforming	Finishing	Rec/Store/Packaging	Other
ed	Large Fab	Composite	Supplier	

QTY Effective :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

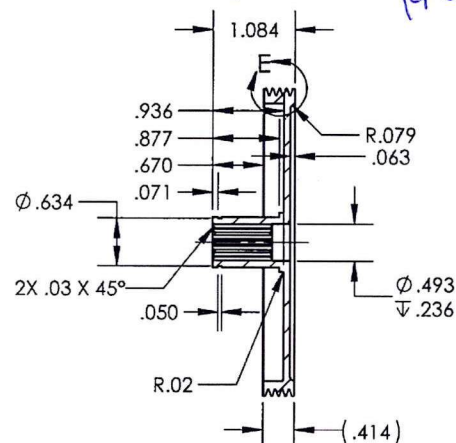
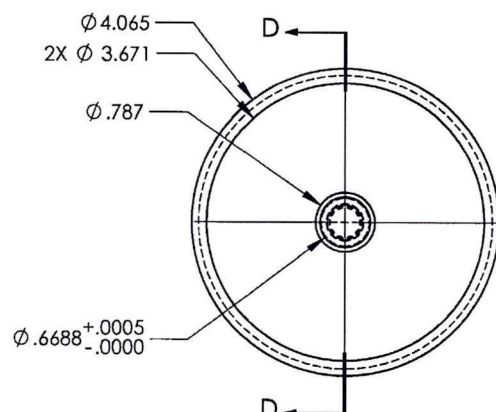
FAULT CATEGORY

Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Bending	Set-up	Folio/Program	Outside Dimensions
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Cuffs	Contamination	Out of Sequence	Part Moved
Crushing	Countersink	Off-set	Drawing
Heat Treat	Cut Too Short	Mislabeled	Finish
Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence

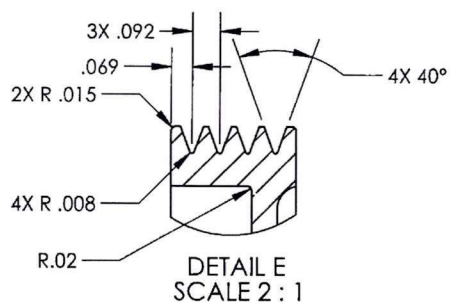
OTHER :

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188490 4-5
190110



SECTION D-D



(-07)
GEARED PULLEY

SPUR GEAR DATA	
NO. OF TEETH	10
MOD	1.0
THREE TEETH	.303
PITCH DIA.	$\phi .428$
DIAMETRAL PITCH	7
PRESSURE ANGLE	30°
MAJOR DIAMETER	.480
MINOR DIAMETER	.395
CASTING OF	INTERNAL GEAR
GEAR STANDRAD	5480

DART AEROSPACE	
TITLE HYDRAULIC PUMP DRIVE TOOL	
DWG NO. RBEL135M-2901-101-07	REV A
MATL 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125
DRAWN BY: KK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: ML	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: NA	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: NA	USED ON MODEL
APPROVED: <i>[Signature]</i>	EUROCOPTER EC135
SCALE 1:2	DATE 08/27/2018 SHEET 6 OF 18

P.J. Machinage (9052 9470 Qc Inc).
1381, Rte Cité-Des-Jeunes,
St-Lazare, Qc
J7T 2B8 **Tel. :** 450 455-0705

Bid 11/01/2019 15594

Sales Rep. : Peter Jones
Reference : RBEL 135M-2901-101-07
Expiration Date : 10/02/2019

Customer : 628

Dart Aerospace Ltd.
Patrick Lussier
1270 Aberdeen St
Hawkesbury, Ontario
K6A 1K7

Ship To :

Same

Fax: 1 613 632-5246

Item No.	Description	Qty	Price	Total	Tx
001	RBEL 135M-2901-101-07 rev A Hydraulic Pump Drive Tool	2	750.00	1 500.00	AB
002	RBEL 135M-2901-101-07 rev A Hydraulic Pump Drive Tool	4	575.00	2 300.00	AB

Material supplied by P.J. Machinage
Price valid : Conditionally if full order
is given and there is only one setup
and one shipment, if not, surcharges
may apply.

Machining price valid 30 days.

Material price valid 1 day only, due
to USA

Freight charge not included.

Delivery is to be discussed the day
we receive the purchase order.

P.J. MACHINAGE
LISEZ ATTENTIVEMENT ET CORRIGEZ
LES ERREURS ÉVENTUELLES. NOUS NE
POURRONS PAS ÊTRE TENUS
RESPONSABLES POUR LES ENDEURS
APRÈS QUE VOTRE APPROBATION AIL
ÉTÉ DONNÉE.

SIGNATURE

NOTA: TI EST AVERTI QUE SEUL
AUX ÉLÉMENTS DE LA SOLUCION.

P.J. Machinage retains ownership of all goods sold and other work-product delivered to or
performed for its customer until full and complete payment of the underlying invoice, even in
circumstances where the part to be machined or materials were provided by the customer. In
cases where the part or materials belonged to the customer before it is remitted to P.J. Machinage
for the purpose of performing work thereon, its delivery to P.J. Machinage shall entail
a transfer of the underlying rights of ownership of the customer over said part or materials

**Note: All the COD Clients must pay 50% up front and the balance
must be paid upon reception.**

A) Regist : 870637832
B) Regist : 1021079932

Subtotal 3 800.00
TPS : 190.00
TVQ : 379.05

Total : 4 369.05

ON



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042245



Supplier: PJM001-VC
P.J. Machinage
1381 Rte Cite-Des-Jeunes
St-Lazare
QC
J7T 2B8
Phone: 450-455-0705

PO No: PO042245
PO Date: 1/11/19
Due Date: 1/28/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188490	RBEL135M-2901-101-07P			Geared Pulley REV A	Firmed	-	1/28/19	4 Ea	0 Ea	4 Ea	\$575.00/Ea	\$2,300.00

4X JAN 24 2019

Grand Total: \$2,300.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/11/19 1:52 PM dart.Lussier.Patrick

Shipping Order

11/01/2019

P.J. Machinage (9052 9470 Qc Inc).
1381, Rte Cité-Des-Jeunes,
St-Lazare, Qc
J7T 2B8

Tel. : 450 455-0705

Order : 7419
Reference : PO042245-S/O : 7419
Bid : 15594
Ship : Votre camion

Customer : 628

Ship To

Dart Aerospace Ltd.
Patrick Lussier
1270 Aberdeen St
Hawkesbury , Ontario
K6A 1K7

Same

Fax: 1 613 632-5246

Item No.	Description	Qty	Qty. Delivere	B/O Qty
J-7419/628	RBEL 135M-2901-101-07 rev A Hydraulic Pump Drive Tool (Geared Pulley)	4	4	0

DAS
38
9-88

P.J. Machinage retains ownership of all goods sold and other work-product delivered to or performed for its customer until full and complete payment of the underlying invoice, even in circumstances where the part to be machined or materials were provided by the customer. In cases where the part of materials belonged to the customer before it is remitted to P.J. Machinage for the purpose of performing work thereon, its delivery to P.J. Machinage shall entail a transfer of the underlying rights of ownership of the customer over said part or materials.

Shipping : Your truck
Package No : _____
Merchandise Received: 23/01/2019

Ref. : _____

PJ Machinage**Certificate of conformance****Sold to:**

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON, K6A 1K7

Supplier address:

PJ Machinage
1381 Route Cité-Des-Jeunes
St-Lazare, Qc, J7T 2B8

Purchase Order: PO042245 ✓

This is to certify that the below names items were inspected and/or tested to your drawings, specifications and purchase order. Objective evidence are shipped with the products and are on file to support the verifications and/or tests and can be made available on request, unless otherwise noted.

<u>Part Number</u>	<u>Quantity</u>	<u>Description</u>
RBEL 135M-2901-101- <u>07 Rev. A</u>	4 ✓	<u>Hydraulic Pump Drive</u> <u>Tool (Geared Pulley)</u>

 , January 23 , 2019

CERTIFICATE OF TEST CERTIFICAT D'ESSAIS



Earle M. Jorgensen
(Canada) Inc.

Page 01 of 01

Certification Date
9-AUG-2018

CUSTOMER ORDER NUMBER
NUMÉRO DE COMMANDE DU CLIENT

135110
PART NUMBER/NUMÉRO DE PIÈCE
503410

EARLE M JORGENSEN CAN DIV RMCL
1255, AVE LAPLACE
VILLE DE LAVAL QC H7C 2N6

Invoice Number
S710096

SOLD TO: P.J. MACHINAGE
VENDU À: 9052-9470 QUEBEC INC
1381 ROUTE DE LA CITE DES JEUNES
SAINT- LAZARE QC J7T 2B8

SHIP TO:
EXPÉDIÉ À:

P.J. MACHINAGE
9052-9470 QUEBEC INC.
1381 ROUTE CITE DES JEUNES
SAINT- LAZARE QC J7T 2

Description: 1018 HR BAR ASTM A576
4-1/2 RD X 20' R/L
HEAT: 50675152/05 ITEM: 503410

Line Total: 1083 LB

Specifications:
ASTM A576 90B ASTM A29 16

CHEMICAL ANALYSIS

C	MN	P	S	SI	CU	NI	CR
0.17	0.73	0.012	0.016	0.35	0.25	0.10	0.10
MO	SN	V	NB	TI	B	N	
0.021	0.011	0.058	0.002	0.001	0.0011	0.00	

RCPT: R461017

COUNTRY OF ORIGIN : USA

MECHANICAL PROPERTIES

DESCRIPTION	YLD STR PSI	ULT TEN PSI	%ELONG IN 02 IN	%RED IN AREA	HARDNESS
	47500.0	76300.0	23.3		

MATERIAL IS FREE FROM MERCURY CONTAMINATION
NO WELD REPAIR PERFORMED ON MATERIAL

COMMENTS

melted and mfg in canada

The above data were transcribed from the manufacturer's Certificate of Test after verification for completeness and specification requirements of the information on the certificate. All test results remain on file subject to examination. /Les informations ci-haut-mentionnées sont transcrites du certificat d'essais du manufacturier après vérification de l'état complet des spécifications inscrites sur le certificat. We hereby certify that the material covered by this report will meet the applicable requirements described herein, including any specification forming a part of the description. /Par les présentes, nous certifions que le matériel couvert par ce rapport rencontre les spécifications décrites ci-haut.

The willful recording of false, fictitious, or fraudulent statements in connection with test results may be punishable as a felony under federal statutes. /Les informations fausses, fictives ou frauduleuses en rapport avec le résultat des essais sont punissables en vertu des lois fédérales.

Material did not come in contact with mercury while in our possession./Par les présentes, nous certifions que le matériel couvert par ce rapport rencontre les spécifications décrites ci-haut.

JOANNE DESPRES

MANAGER QUALITY ASSURANCE
GÉRANT DE L'ASSURANCE QUALITÉ

Benoit Mayer 



Certificat de Conformité / Certificate of Compliance

(016137-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

016137 - 1

Livré à / Ship to

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes
 St-Lazare, QC, J7T2B8
 CANADA

Tel.: 450-455-0705 Fax: 450-455-1167

Client / Customer:

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes
 St-Lazare, QC, J7T2B8
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Jan-2019		Aman		135868				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEL135M-2905-101-07 Rev.	RBEL135M-2905-101-07 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] ASTM B633, TYPE 1, SC2: ZINC, 0.0003" ***	ZINC CH	8	8	0	0	0

Notes Additionnelles / Additional Notes

ps

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.